

Date: Wednesday, 9/12/2007 12:16:28 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HANDLE WELDMENT
Job Number	: 34635		
Estimate Number	: 12064		
P.O. Number	: N/A	Part Number	: D3355045
This Issue	: 9/12/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D3355 REV B
First Issue	: N/A	Project Number	: N/A
Previous Run	: 30719	Drawing Revision	: B
		Material	: N/A
Written By	: <u> </u>	Due Date	: 9/21/2007
Checked & Approved By	: <u> </u>	Qty:	4 Um: Each
Comment	: est rev A 06.01.20 new issue EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D33551	handle tip
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

pick:



qty	part number	description	batch
1	D3355-1	handle tip	B30776

Pl 07.09.20

2.0	D33553	LARGE TUBING
-----	--------	--------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

pick:



qty	part number	description	batch
1	D3355-3	large tubing	B34625 → 3 B26942 → 1

Pl 07.09.20

3.0	238043	DOWEL PIN .250 X 1.5
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

pin



Batch: M16684

Pl 07.09.20

4.0	VA7130	spring plunger
-----	--------	----------------



Pl 07.09.20

Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

pick:



qty	part number	description	batch
1	VA-7130	spring plunger	M103546

Pl 07.09.20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DD Date: 07/09/21
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/09/21	#910	Pin is stuck and doesn't operate correctly. 2 SCVAP R.C. Faulty Parts	<i>[Signature]</i>	Remove P/N and replace B# <u>M103546</u> P/N# <u>VA-7130</u>	<i>[Signature]</i> 07/09/21	En 07/09/21	<i>[Signature]</i> 07/09/21	En 07/09/21

NOTE: Date & initial all entries

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User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HANDLE WELDMENT

Job Number: 34635

Part Number: D3355045

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



(4)

Comment: Weld assembly as per dwg

Pl 07-09-20

6.0

DO NOT USE

WELD INSPECTION

Qc5 En 2/02/20

Qc9

2/07/09/20 (4)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

FL 07/09/20 (4)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



(4)

Comment: LARGE FABRICATION RESOURCE 1

Install spring plunger per dwg D3355

Pl 07-09-21

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 2/01/21 (4)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *WS23*

Pl 07-09-21

(4)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

2/07/09/21

Job Completion



U 07-09-21

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

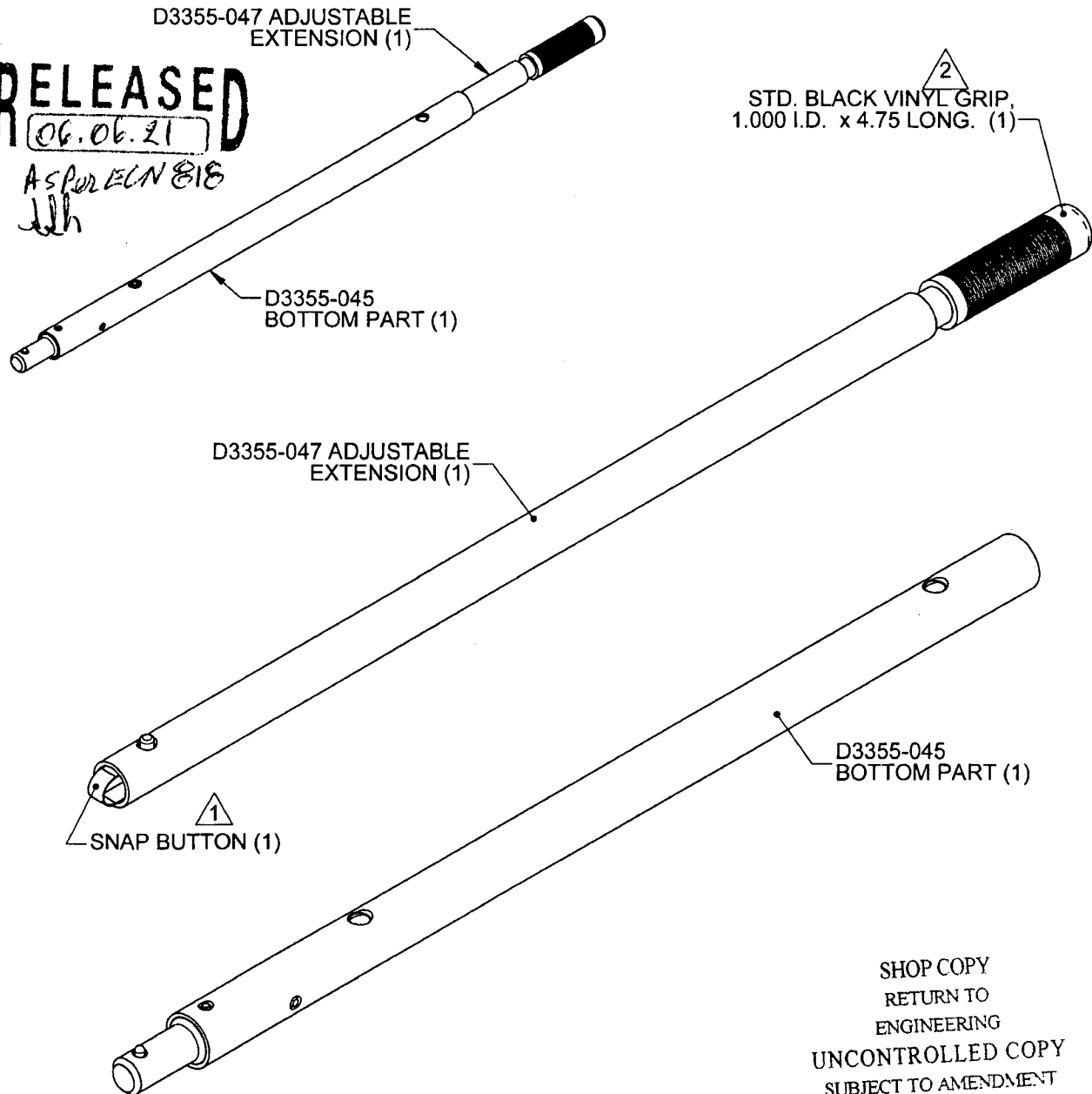
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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DATE 06.05.31		TITLE HANDLE WELDMENT	SCALE 1:8
A	05.02.07	NEW ISSUE	
B	06.05.31	EDITED NOTE 1 (SHEET 2), UPDATE DETAIL B	

RELEASED
06.06.21AS PER ECN 818
[Signature]**D3355-041 HANDLE ASSEMBLY****NOTES:**

- 1) POSSIBLE SUPPLIER: REID TOOLS SUPPLY CO. P/N VA-2160
- 2) POSSIBLE SUPPLIER: REID TOOLS SUPPLY CO. P/N GP-1R

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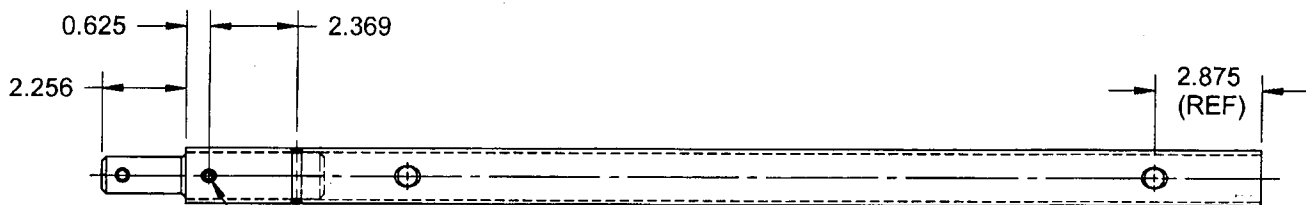
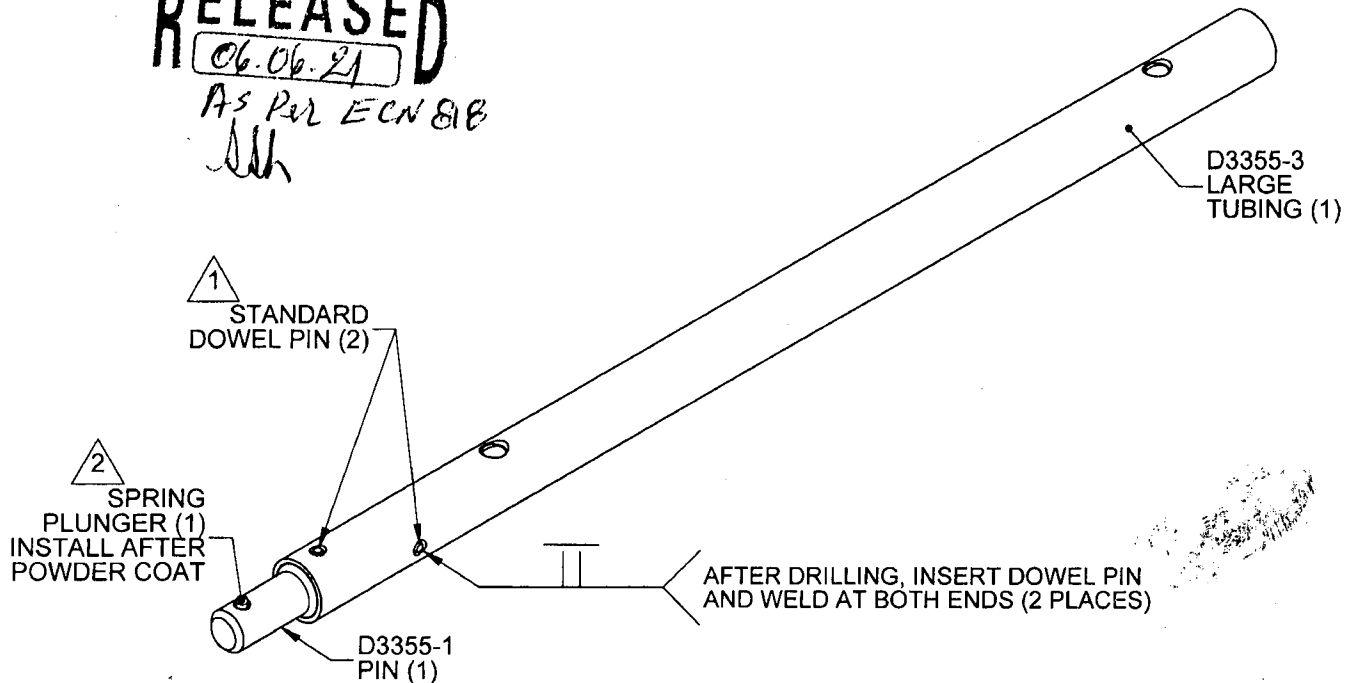
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DATE 06.05.31	TITLE HANDLE WELDMENT		SCALE 1:5

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AS PER ECN 818

[Signature]

DRILL 90° FROM EACH HOLES
Ø0.250 (DRILL THRU (2 PLACES) AND
CHAMFER 0.06 x 45° (4 PLACES)

D3355-045 BOTTOM PART**NOTES:**

- 1) STEEL STANDARD GROUND DOWEL PIN, Ø0.250 X 1.50 LONG
POSSIBLE SUPPLIER: SPAENAU, P/N 238-043
- 2) SPRING PLUNGER, POSSIBLE SUPPLIER: REID TOOLS SUPPLY CO. P/N VA-7130
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.5
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.010 TO 0.020

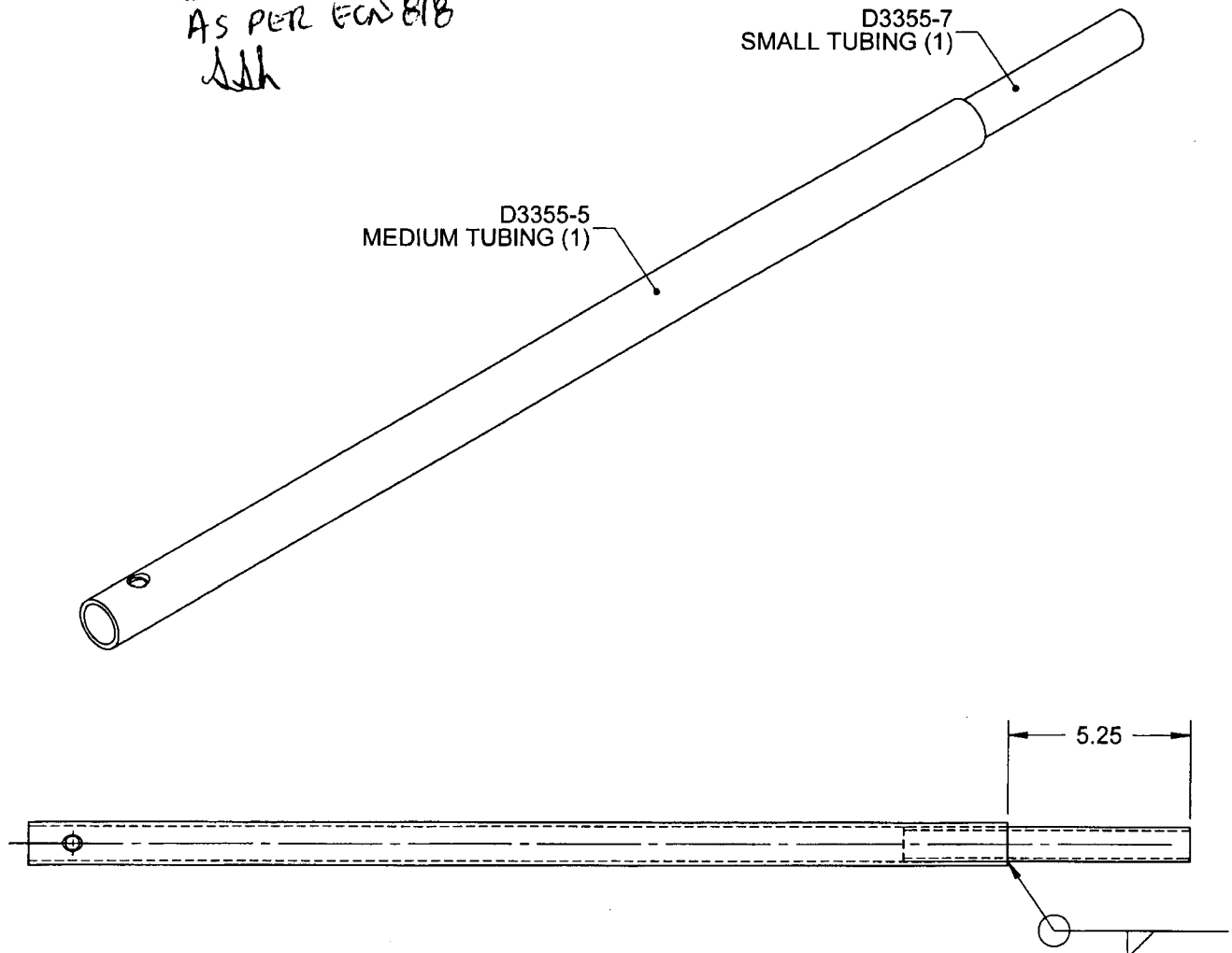
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[Signature]**D3355-047 ADJUSTABLE EXTENSION****NOTES:**

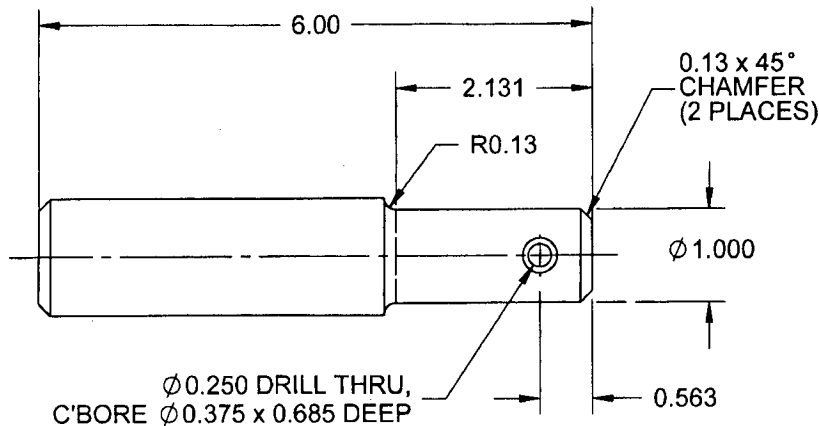
- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.5
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

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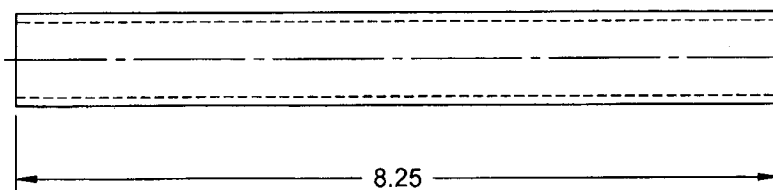
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**RELEASED**
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*AS PER ECN 818***D3355-1 PIN****D3355-1 NOTES:**

- 1) MATERIAL: AISI-4130/ AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE-B7/ A29-03/ A322-91 OR UNS#-G41400 ROUND BAR, (REF. DART SPEC. M4140H-R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

**D3355-7 SMALL TUBING****D3355-7 NOTES:**

- 1) MATERIAL: AISI 1018-1025 MILD STEEL SEAMLESS ROUND TUBING (REF. DART SPEC. M1020TR1.000W.095)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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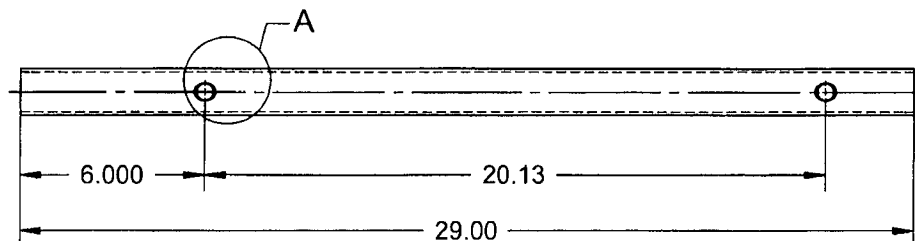
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DATE 06.05.31	TITLE HANDLE WELDMENT	SCALE 1:6	

CHAMFER $\phi 0.687$ (11/16)
x 45°, 0.060 DEEP
(2 PLACES)

$\phi 0.531$ (17/32) DRILL
THRU (2 PLACES)

DETAIL A
SCALE 1 : 2



D3355-3 LARGE TUBING

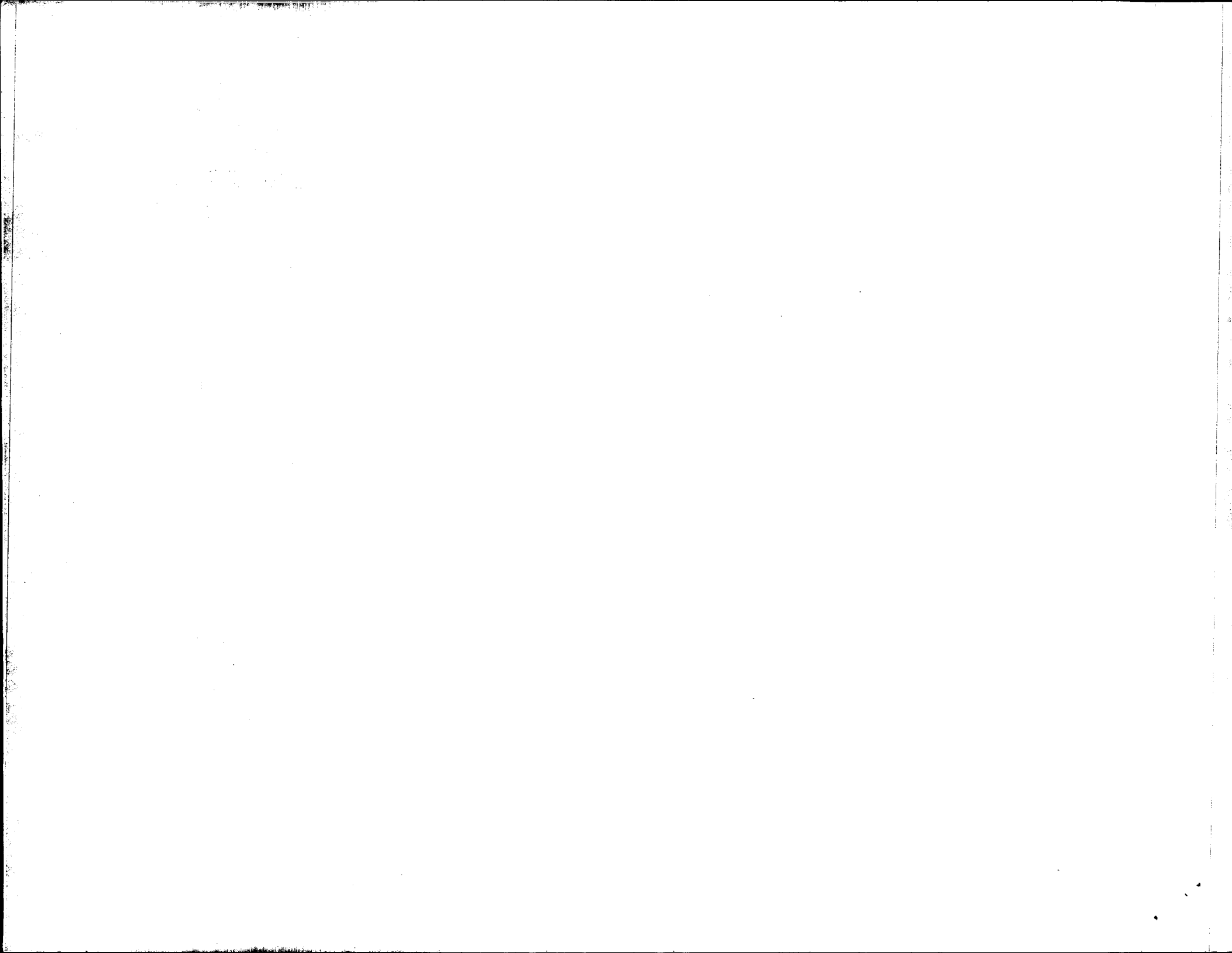
NOTES:

- 1) MATERIAL: AISI 1018-1025 MILD STEEL SEAMLESS ROUND TUBING
(REF. DART SPEC. M1020TR1.500W.109)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.015 TO 0.030

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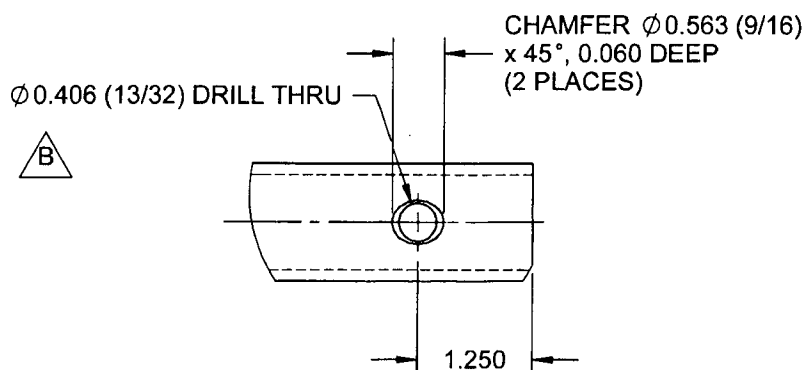
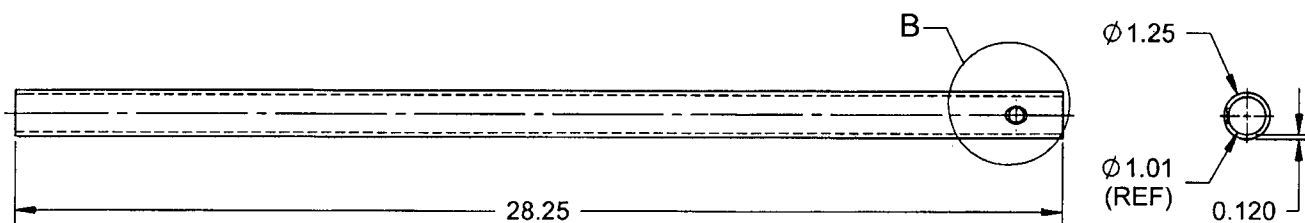
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[Signature]**DETAIL B**
SCALE 1 : 2**D3355-5 MEDIUM TUBING****NOTES:**

- 1) MATERIAL: AISI 1018-1025 MILD STEEL SEAMLESS ROUND TUBING
(REF. DART SPEC. M1018TR1.250W.120)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.015 TO 0.030

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